Work Order				*87	' 515*				Page 1
Revision ID:	0350-636-043 Vearshoe			Accept	*N9000	7401	೧ ೧*	Setup Star Stop	14.21
Start Date: 7 Required Date: 8 Reference:		ety: 2.00 Qty: 2.00	*2* *2*		Cust Item II Customer:) :			
Approvals:	Process Plan:QC:		te: <i> 2/07/6</i> te:	Tooling: SPC (Y/N):	Date Date Date Date Date Date Date Date			Run Star Stop	"INFC I"
Sequence ID/ Work Center !D	Operati Descrip			Set Up/ Run Hours	Tool ID	Tool# Pi	an Accept ode Qty	Reject Qty	Reject Insp. Number Stamp
Draw Nbr	Revision Nb								
N/A 100 *1 \\ \Cappa \\ \C	Rev F	ENT CONTROL Memo Photocopy D350-6		0.00 0.00 0.00 labels per PPPD350-6	Mioles		H) <u>for</u>	MLJ 12-10-18
*110 *110* Packaging Packaging	Pick Kit	Memo		0.00			2x		8P 12-10-
115 *115* QC Ouality Control	QC4- 100	% Inspect kits for cor	npleteness	0.00	Se Miolis		(d)		

,

कृते . . .

NCR:	Yes /	No				WORK ORDER NON	-co	NFOR	MANCE / UP	DATE	•		3
											QA Closed:	Date:	. \$
Work Ord	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	2
Part f						Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	i	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	c	hief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							FALL	LT CATE	CORV				
Landii	ng Gea					General	FAU	LICAIL	GORT	· · · · · · · · · · · · · · · · · · ·			
	Bell Cell Cra	nding ntre No ncks ushed/C ffs at Treat pection ples in	Strip in Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Unance led	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	1101	que wa	aves in E	xcrusion	l l	Drawing	- 1	Jout of C	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde July-19-12 11:1		7515		*875	515*							Page 2	<u> </u>
Item ID: Revision ID: Item Name:	D350-636-0	043		Accept	*N900	040	100	ገ*	Setup	Start Stop	1.7	S1* S2*	
Start Date: Required Date: Reference:	7/10/12 8/10/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item 1 Customer:	D:							
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):		nte:			Run	Start Stop		R1* R2*	
Sequence ID/ Work Center II 120 *120* Packaging Packaging	D	Operation Description Packaging Memo Identify and Location: PPP Rev:	pack for shipping as per	Set Up/ Run Hours 0.00 0.00 PPP D350-636-043	Tool ID	Tool#	Plan Code	Accept Qty	t Re		Reject Number	Insp. Stamp	f
130 *130* QC		QC21- Final Inspection	Work Order Release	0.00					/-	2/1	0/16		<u> </u>

Memo

130

Quality Control

W12.00.18

NCR:	Yes	1	No
NUK:	res	/	INO

DQA: _____ Date: _____

NCR:	Yes	/ No				WORK ORDER NON	I-COI	NFORI	MANCE / UP	DATE			,
		•							-		QA Closed:	Date	, a
Work Ord	er.					DISPOSITION				AGAINST D	EPARTMENT	PROCESS	
VVOIR OIG	C1.					Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part I	No.					Scrap	_	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	No.					Work Order Update			Large Fab	Composite		Supplier	
		ı					- 1	,		* - · -	Cinn 0		
Root		5.4.	.	0.	Desci	ription of work order update		Initial		tion	Sign & Date	Verification	QC Inspector
Cause loc/Data		Date	Step	Qty		or Non-conformance	- Cr	nief Eng	Desc	ription	Date	verification	QC Inspector
quip/Tooling													
perator													
faterial													
etup													
ther													
rocess											·		
upplier										**.			
raining													
napproved													
							FAUL	T CATE	GORY				
Landi	ng (Gear			_	General				-	_	_	-
		Bending				Bend		Grain		<u> </u>	Ovalized		Pressure/Forced
		Centre No	t Concer	itric to (o/s	BOM/Route	\vdash	Hardwa		-	Over/Under	 	Temperature/Cure
		Cracks			L	Broken/Damaged	<u> </u>	-1	on Incomplete		Part Incorred	 - 	Weld
		Crushed/C	Crimped.		<u> </u>	Burrs	<u> </u>	4	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	_	Cuffs			_	Contamination	<u> </u>	Mainte		-	Part Moved		
		Heat Treat			<u> </u>	Countersink	_	Mislabe		-	Positioned V	_	٦٠٠
	-	Inspection	•	Tube	-	Cut Too Short	-	Misread	I	L	Power Loss/	Surge	Other
		Ripples in			\vdash	Drill Holes	-	Offset					
		Torque W		xtrusior	` -	Drawing		1	Calibration				
		Turning Se			-	Finish	<u> </u>	1	equence				
		Wave/Twi	ist in Tub	e		Folio	L	Outside	Dimensions				

Picklist Print Page 1 July-19-12 11:12:53 AM Work Order ID: 87515 D350-636-043 - Start Date: 7/10/12 Required Date: 8/10/12 Parent Item: Start Qty: 2.00 Required Qty: 2.00 Parent Item Name: Wearshoe IPP Rev:B 10.05.20 added QC4 IPP Rev: A New Issue 07-12-17 DD Comments: DD verf:EC Qty per Kit Total Component Item ID/ Replacement Mfg/ Last Unit of Qty on Qty Date Status Bin **Primary** Route Hand Item Name Location Seq ID Measure Issued Issued Item ID Location Qty Purch Item No 110 Each 1,335.0000 76 Purchased Loc Qty Loc Code Location FP001 115835 ST350 1328 116419 28 117343 13 117764 117872 2 119749 23 120423 28 121255 227 121708 500 122141 500 184.0000 110 Each No Purchased Location Loc Qty Loc Code ST351 184 113149 14 116169 117313 10 117619 12

> 30 2

100

121541

122141

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-	COI	VFORM	MANCE / UP	DATE			
												QA Closed:	Date:	
Nork Ord	ter:						DISPOSITION				AGAINST DE	EPARTMENT	/PROCESS	•
Part							Rework Scrap Use-as-is	L	ſ	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	⊣	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR	No.						Work Order Update			Large Fab	Composite		Supplier	
Root					Desc		otion of work order update	1	nitial		tion	Sign &		
Cause		Date	Step	Qty		C	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining									,					
Порриотес	1	I	L	<u> </u>			F	AUL	T CATE	GORY			I	
Land	ing (Gear	-				General							
		Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection Ripples in Torque W	Crimped. t n Strip in Bend	Tube	- - - -		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ nance led	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Turning So			ľ		Finish	Out of Sequence						

Outside Dimensions

Wave/Twist in Tube

Folio

Picklist Print
July-19-12 11:12:53 AM

Page 2

Work Order ID:	87515								
· Parent Item:	D350-636-043						Star	t Date: 7/10/12	Required Date: 8/10/12
Parent Item Name:	Wearshoe						Star	rt Qty: 2.00	Required Qty: 2.00
AN960G10L- washer	NAS1149C0332R	Purchased	No		110	Each	21.0000	42	84/23248 SP
				<u>Location</u>	Loc Qty		Loc Code		
				ST	21			.	
. 1				107534	21				
D3535-13 Wearshoe		Manufactured	No		110	Each	22.0000		2
Wearshoe				Location	Loc Qty		Loc Code		Si
				FP001	22				
				79850	1				
				81353	8				
. 1				86229	13			<u> </u>	\mathscr{L}
D3535-25 Wearshoe		Manufactured	No	·	110	Each	25.0000	0	1385 50
Wearshoe	4			<u>Location</u>	Loc Qty		Loc Code	9	
				FP001	25				
				62233	1				
				81357	1				
				83387	16				<u></u>
				83899	7				<u> </u>
D3535-35 Wearshoe		Manufactured	No		110	Each	35.0000	P	90092
				Location	Loc Qty		Loc Code	_	501210-
				FP001	35				_ 3F 10-10
				67598	1				<u> </u>
				70815	1				
				78873	13				
				79849	1				_
				83638	7				
				86191	12				

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UPI	DATE	•		,
									• 		QA Closed:	Date	<u>:</u>
Work Ord	۵r۰				·	DISPOSITION				AGAINST DE	PARTMENT	PROCESS	•
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root						ption of work order update		Initial		tion	Sign &	_	
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved			,										
							AUL	LT CATE	GORY				
Landi		Gear Bending Centre No	ot Concer	ntric to () D/s	General Bend BOM/Route		Grain Hardwa	re		Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure
	_	Crushed (Criman ad			Broken/Damaged		4	on Incomplete	Inclose	Part Incorred		Weld Wrong Stock Pulled
		Crushed/0 Cuffs	umpea.			Burrs Contamination		Mainte	ions Incomplete/l nance	Unclear	Part Lost/Mi Part Moved	22111R	
·•		Heat Trea	t			Countersink		Mislabe	led		Positioned V		_
		Inspection	•	Tube	<u> </u>	Cut Too Short Drill Holes	-	Misread Offset	l	L	Power Loss/	Surge	Other

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print
July-19-12 11:12:53 AM

Page 3

Work	Order ID:	87515									
	nt Item:	D350-636-043						Start l	Date: 7/10/12	Required Date: 8/10/12	
	nt Item Name:	Wearshoe							Qty: 2.00	Required Qty: 2.00	
D3530 Gaske			Manufactured	No		110	Each	16.0000		389646 8	P
n					Location	Loc Oty		Loc Code			
					FP002	16		•			<i></i>
_	}				81344	16				<u> </u>	
Gaske	5:25 t		Manufactured	No		110	Each	15.0000		3890 D	
The state of the s					Location	Loc Qty		Loc Code			10
					FP	15					
					83900	15				<u></u>	
Sparke			Manufactured	No		110	Each	35.0000	1 B90	843 80	
40					Location	Loc Qty		Loc Code	•		
					FP "	11					
					85605	11					
					FP002	11				<u></u>	
					82065	11				<u></u>	
					FP012	13				1	
					86251	13					
Sa Wearr	7=1 pad		Manufactured	No		110	Each	125.0000	B	90197 ST	<u>ک. </u>
					Location	Loc Qty		Loc Code		12-10-17	
					FP002	125				_ '5 10-17	`• _
					83254	1					_
					83255	3			**************************************		
					85457	22					SV
					85458	44				<u></u>	
					86238	55					
						_					

							•					DQA:	Date:	<u> -</u>
NCR:	Yes	/ No					WORK ORDER NON-O	100	NFOR	MANCE / UPDA	TE	-		,
												QA Closed:	Date:	
Work Ord	er:						DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	•
Part . NCR		······					Rework Scrap Use-as-is Work Order Update			Machining noforming	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root		· · · · · · · · · · · · · · · · · · ·	i	1	Dos	cri	otion of work order update	r - i	nitial	Action		Sign &		
Cause		Date	Step	Qty	Des		or Non-conformance		iiiiliai iief Eng	Descript		Date	Verification	QC Inspector
oc/Data							· · · · · · · · · · · · · · · · · · ·			·				
quip/Tooling Operator														
Material etun	-									,				
etup Other														
rocess														
upplier														
raining														
napproved														
								AUL	T CATE	GORY				
Landi		1			ſ		General		1			1		7
*	_	Bending			- /s		Bend	<u> </u>	Grain			Ovalized	<u> </u>	Pressure/Forced
	<u> </u>	Centre No	t Concen	itric to (J/S		BOM/Route		Hardwa		<u> </u>	Over/Under	<u> </u>	Temperature/Cure Weld
	-	Cracks Crushed/C	"rimon a d				Broken/Damaged Burrs	_	1 '	on Incomplete ions Incomplete/Uncl	loor —	Part Incorrect Part Lost/Mis	<u> </u>	Wrong Stock Pulled
•		Cuffs	.nmpea,				Contamination		Mainte	·	lear	Part Moved	22111R	
		Heat Treat	t				Countersink	-	Mislabe		-	Positioned W	/rong	
	\vdash	Inspection		Tube			Cut Too Short	┢	Misread			Power Loss/S		Other
	_	Ripples in					Drill Holes	—	Offset	•	<u> </u>	1 2 2000/1		
	H	Torque Wa		xtrusior	,		Drawing		i	Calibration				
		Turning Se					Finish	-	4	equence				

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

5.0 **PARTS LIST** (D350-636-011/-012/-013/-014 SKIDTUBES AT CHANGE 003)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty, -043	Part Number	Description
	х				V	D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		x				D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			x			D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
				х		D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
					X	D350-636-043	WEARSHOE KIT (REPLACES -041 KIT)
					L		
1	1		ļ		ļ	D2750-041	SKIDTUBE ASSEMBLY, LH
1		1				D2750-042	SKIDTUBE ASSEMBLY, RH
1			11	L		D2750-043	SKIDTUBE ASSEMBLY, LH
1				1	<u> </u>	D2750-044	SKIDTUBE ASSEMBLY, RH
*1	1					D2750-1	SKIDTUBE WELDMENT, LH
*1		1			<u>I</u>	D2750-2	SKIDTUBE WELDMENT, RH
*1			1		Í	D2750-3	SKIDTUBE WELDMENT, LH
*1				1		D2750-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
					6		
*5	1	-1	1	1	1	AN8C35A	BOLT (REPLACES AN8-35A)
*6A	2	2	2	2	in in	AN960C816L	WASHER (REPLACES AN960JD816)
*6B	2	2	2	2	li.	NAS1515H8L	WASHER
*7	1	1	1	1	11	MS21083C8	NUT (REPLACES MS21083N8)
			<u> </u>	'_	li	W021003C0	1401 (NEFEACES 14132 1063146)
-8	1		1		n	D3488-041	PLADE EITTING LIP (DEDI ACES DOZAS 4)
*8		1	- '	1	11	D3488-042	BLADE FITTING, LH (REPLACES D2742-1) BLADE FITTING, RH (REPLACES D2742-2)
9	1	1	4	1		D2741	BLADE FITTING, RH (REPLACES 02/42-2)
			1	2	<u> </u>		
10	2	2	2	2		AN8C21A AN960C816L	BOLT (REPLACES ANS-16A)
11A	2					·	WASHER (REPLACES AN960JD816)
11B	2	2	2	2	- P	D3672-13	WASHER
12	2	2	2	2	<u> </u>	MS21083C8	NUT (REPLACES MS21083N8)
*13	4	4	4	4	1	ALS4-1032-225	INSERT
					L Ł		
*14	4	4	4	4		AN6C44A	BOLT (REPLACES AN6-44A)
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	١ ١	MS21043-6	NUT (REPLACES MS21042L6)
*17	8	8	8	8		D3631-1	WASHER (REPLACES NAS1515H8L)
*18	4	4	4	4		ALS4-1032-225	INSERT (REPLACES NAS1330S3KB166)
*19	4	4	4	4		AN3C6A INUED ON NEXT PA	BOLT (REPLACES AN3-6A)

(CONTINUED ON NEXT PAGE)

DART AEROSPACE USA, INC.

REFERENCE ONLY

IIN-D350-636 Page 25 of 31

(CONTINUED FROM PREVIOUS PAGE)

item	Qty -011	Qty -012	Qty -013	Qty -014	/Qty /-043	Part Number	Description
*20A	4	4	4	4	_	AN960C10L	WASHER (REPLACES AN960JD10)
*20B	4	4	4	4		NAS1515H3L	WASHER (REPLACES AN960JD10)
*22	5	5	5	5	<i>(</i> *5	D3537-1	WEARPAD (REPLACES D2648-3)
*23A	1	1	1	1		D3535-13	WEARSHOE (REPLACES D2656-13)
*23B	1	1	1	1	11 =	_D3536-13	GASKET
*24A	1	1	1	1	/ 1	D3535-25	-WEARSHOE (REPLACES D2746)
*24B	1	1	1	1 ,	1	D3536-25	GASKET
*25A	1	1	1	1 ,	1	D3535-35	-WEARSHOE (REPLACES D2656-35)
*25B	1	1	1	1	1	D3536-35	GASKET
*26A	38	38	38	38	/ 38	AN3C5A	BOLT (REPLACES AN3-5A)
*26B	4	4	4	4	- 4	AN3C7A	BOLT (REPLACES AN3-7A)
*27	42	42	42	42 -	42	AN960C10L *	WASHER (REPLACES AN960JD10)
*28	38	38	38	38		ALS4-1032-225	INSERT (REPLACES NAS1330S3KB166)
*30	8	8	8	8	 	D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32	·		8	8		D3492-045	PLUG ASSEMBLY
***43	2	2	- 2	2	<u> </u>	D3493-1	WASHER
50	2	2 .				D3532-1	SPACER
	l	1		1	1	i .	

^{*} PART OF D2750-041/-042 OR D2750-043/-044 ASSEMBLY ** TO BE SUPPLIED BY CUSTOMER

^{***} ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM